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Palushaj

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(54) **ABRASIVE PREPARATION DEVICE WITH AN IMPROVED ABRASION ELEMENT ASSEMBLY**

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See application file for complete search history.

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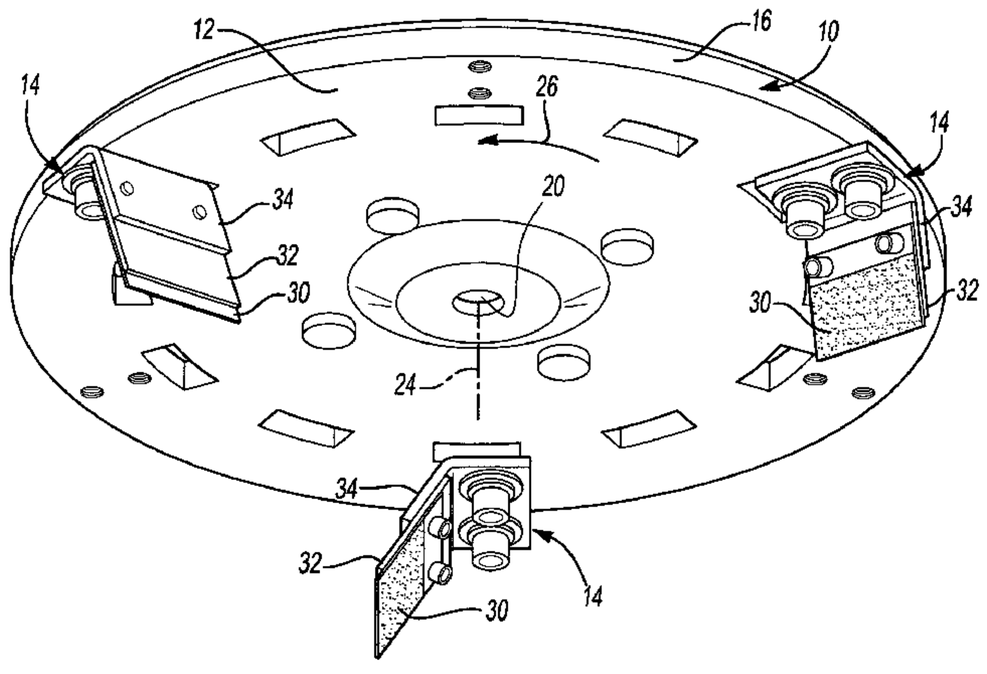
(57) **ABSTRACT**

An abrasive abrading a grinding device (**10**) having a housing (**12**) for moving over a concrete surface. The housing has depending abrasion elements (**14**) with a substrate layer (**30**) and a backing layer (**32**) mounted to a support bracket (**34**) that in turn is affixed to the housing. The substrate layer (**30**) has a front surface (**44**) with a distal section (**40**) having abrasive particles (**42**) brazed thereon with brazing material (**46**).

29 Claims, 4 Drawing Sheets



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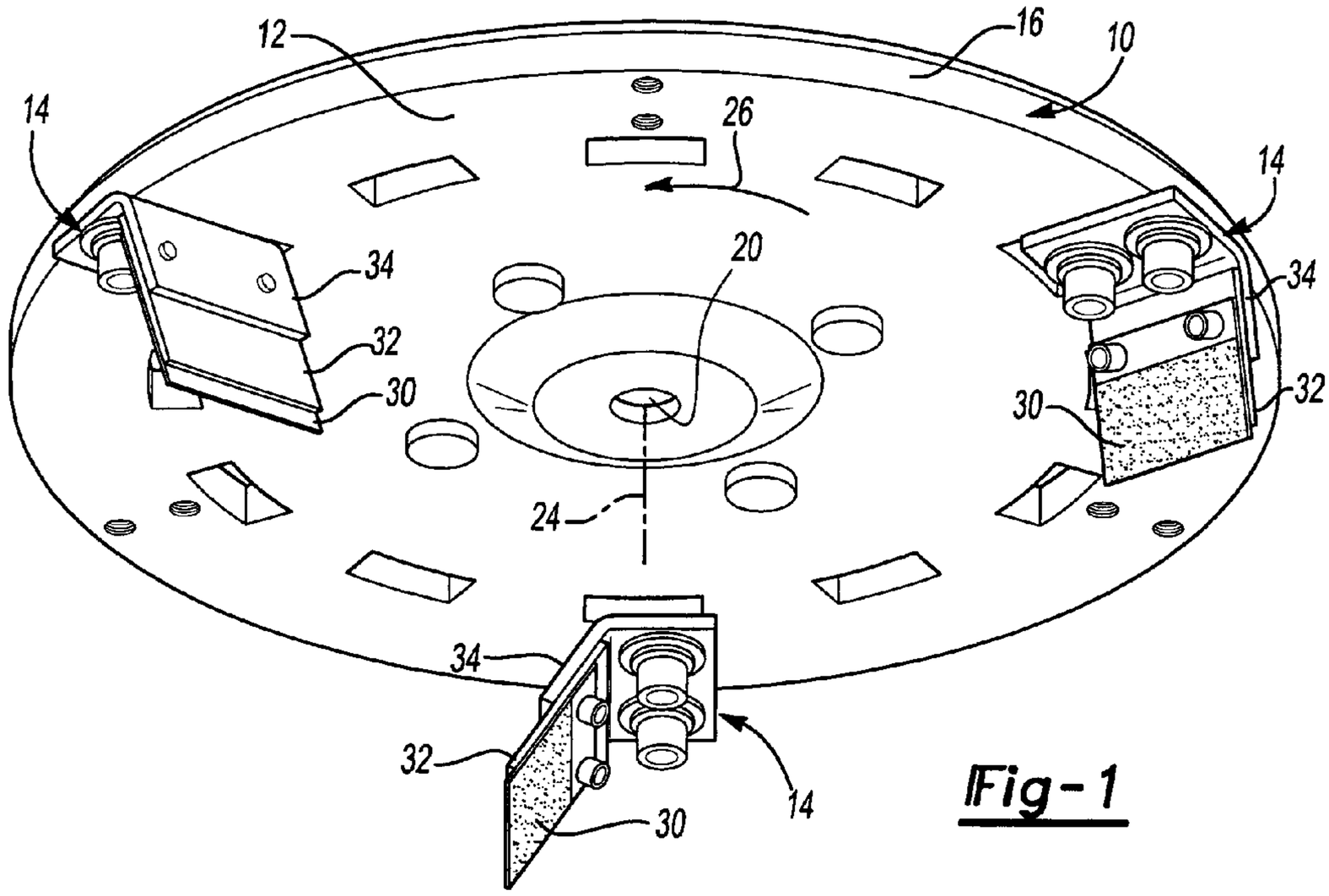
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Fig-1

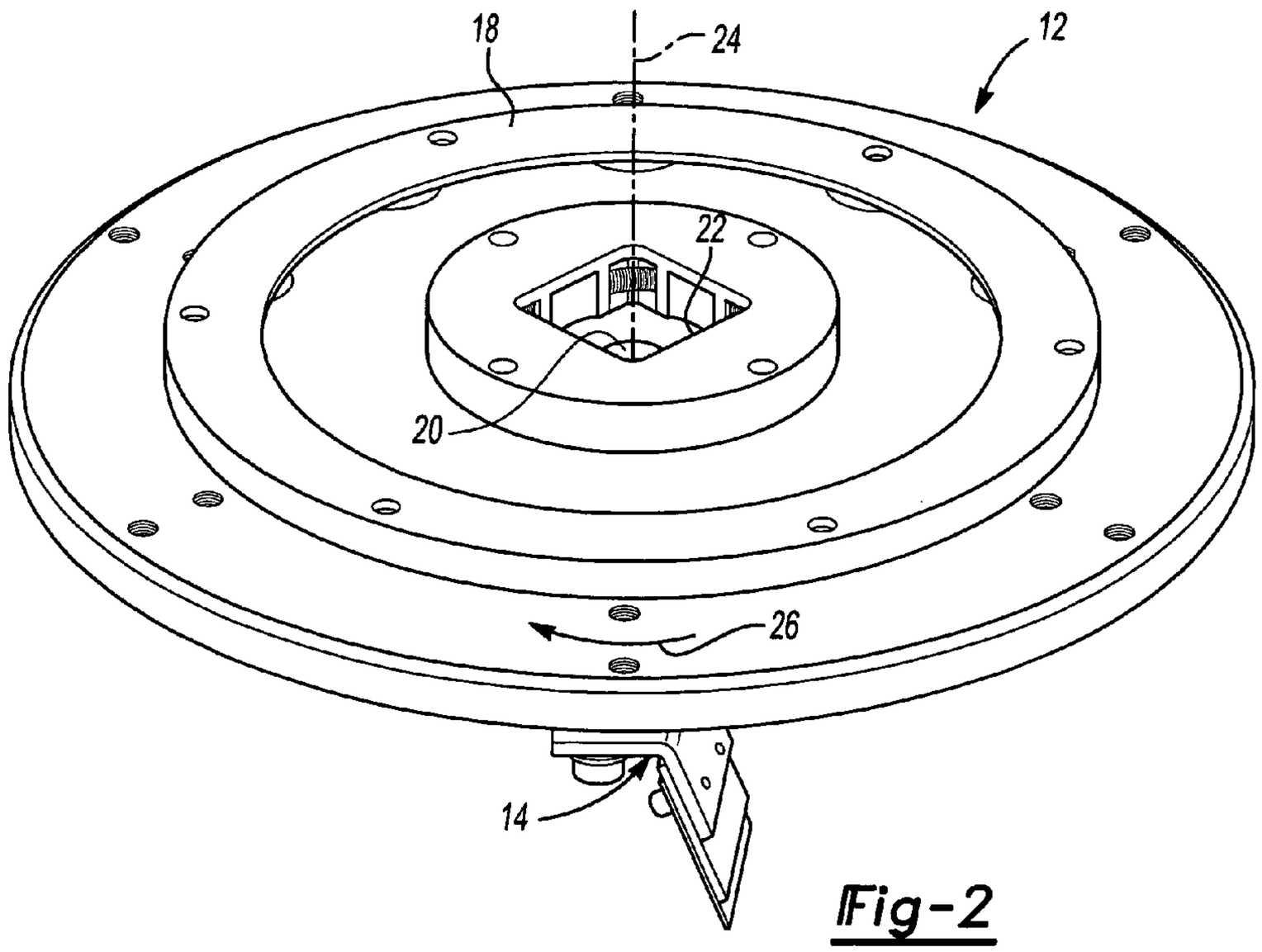
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Fig-2

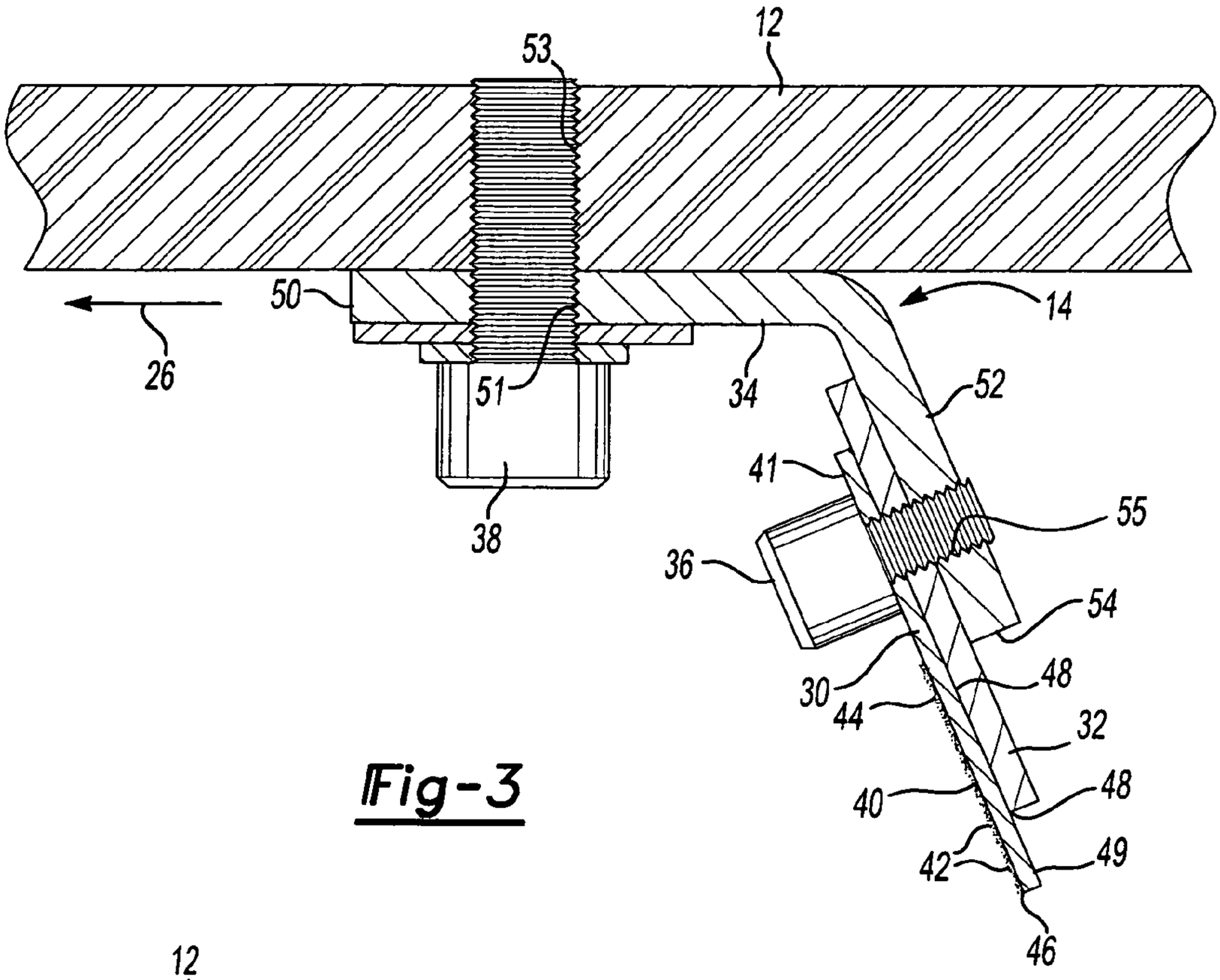
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Fig-3

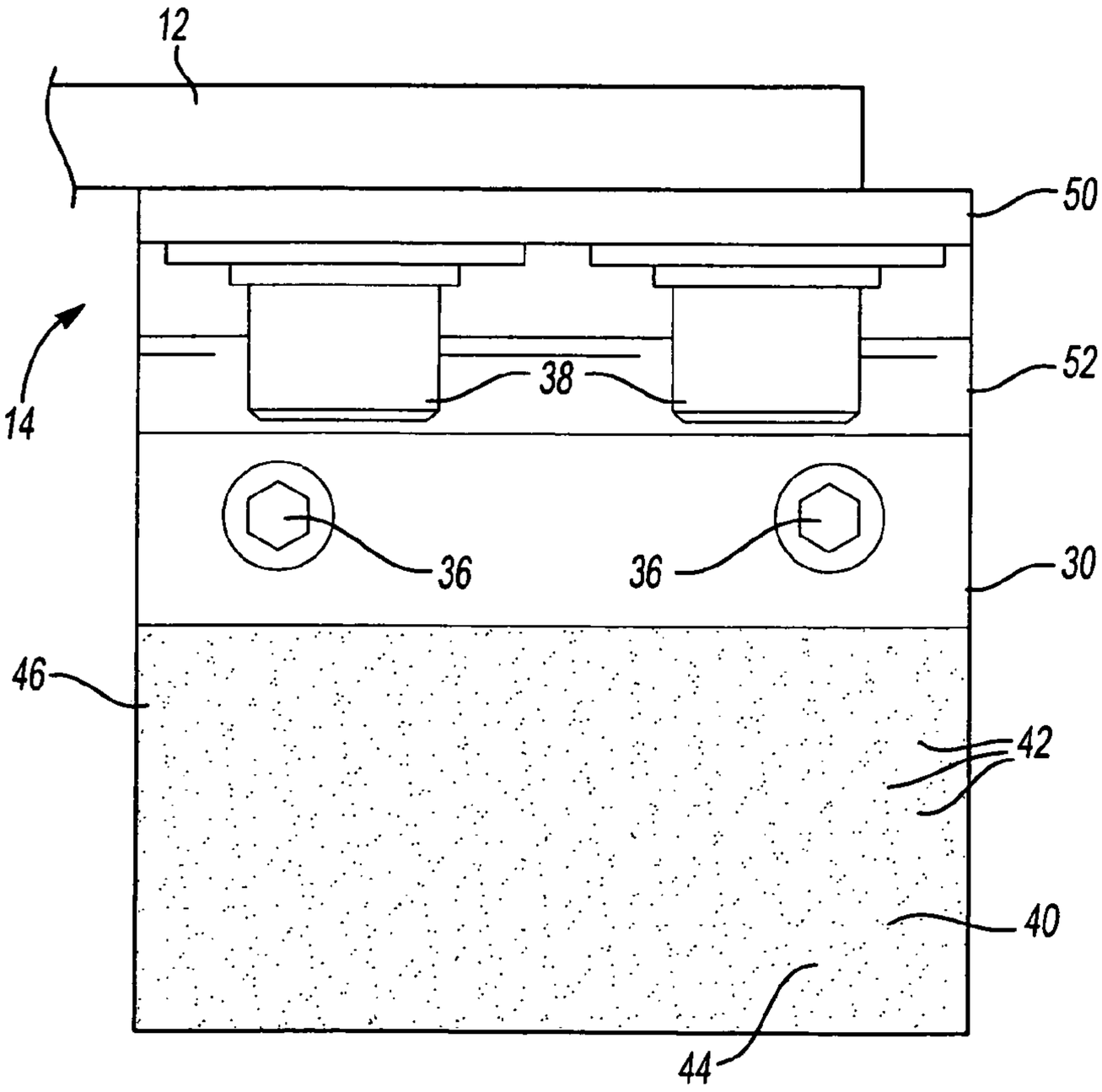
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Fig-4

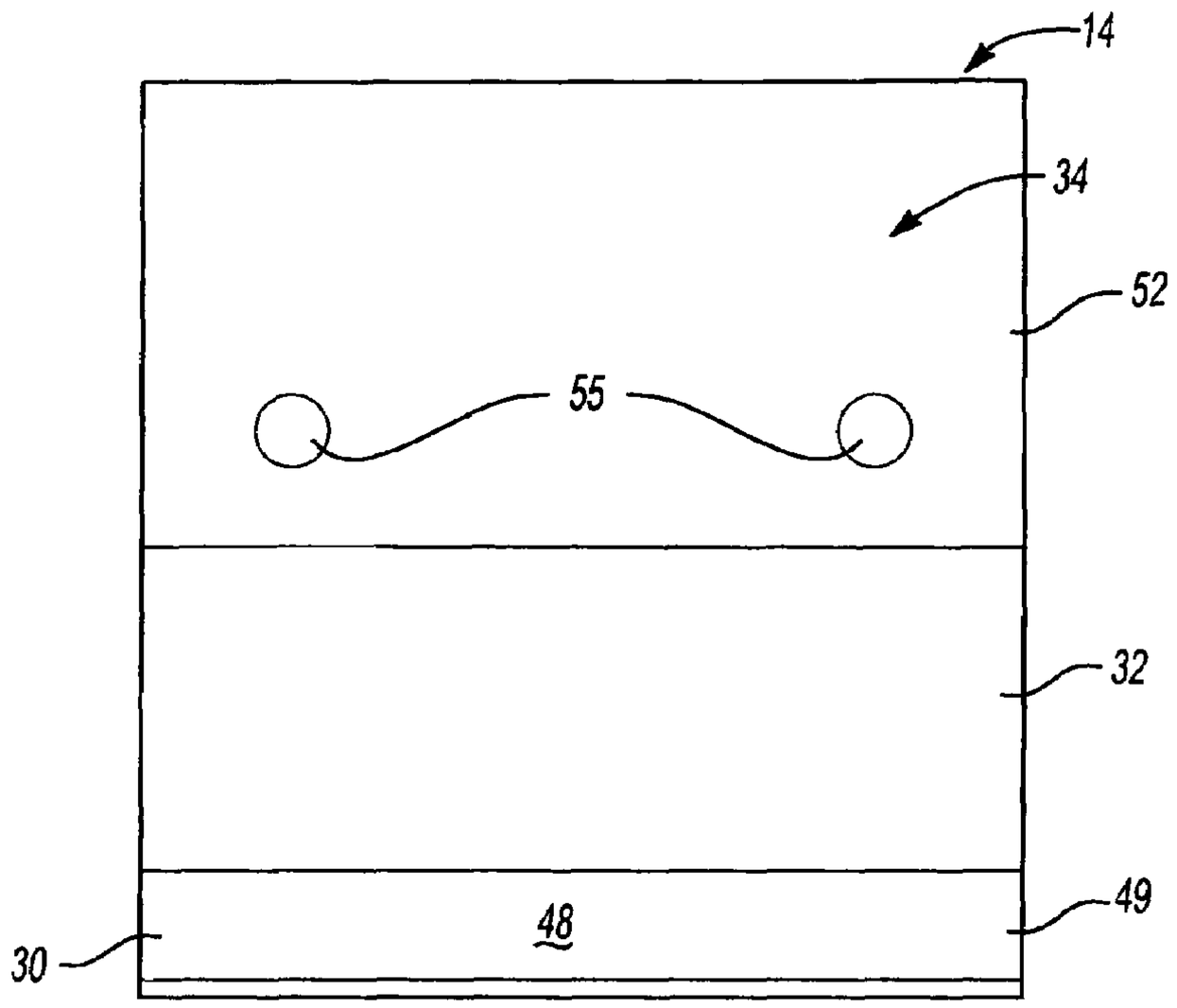
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Fig-5

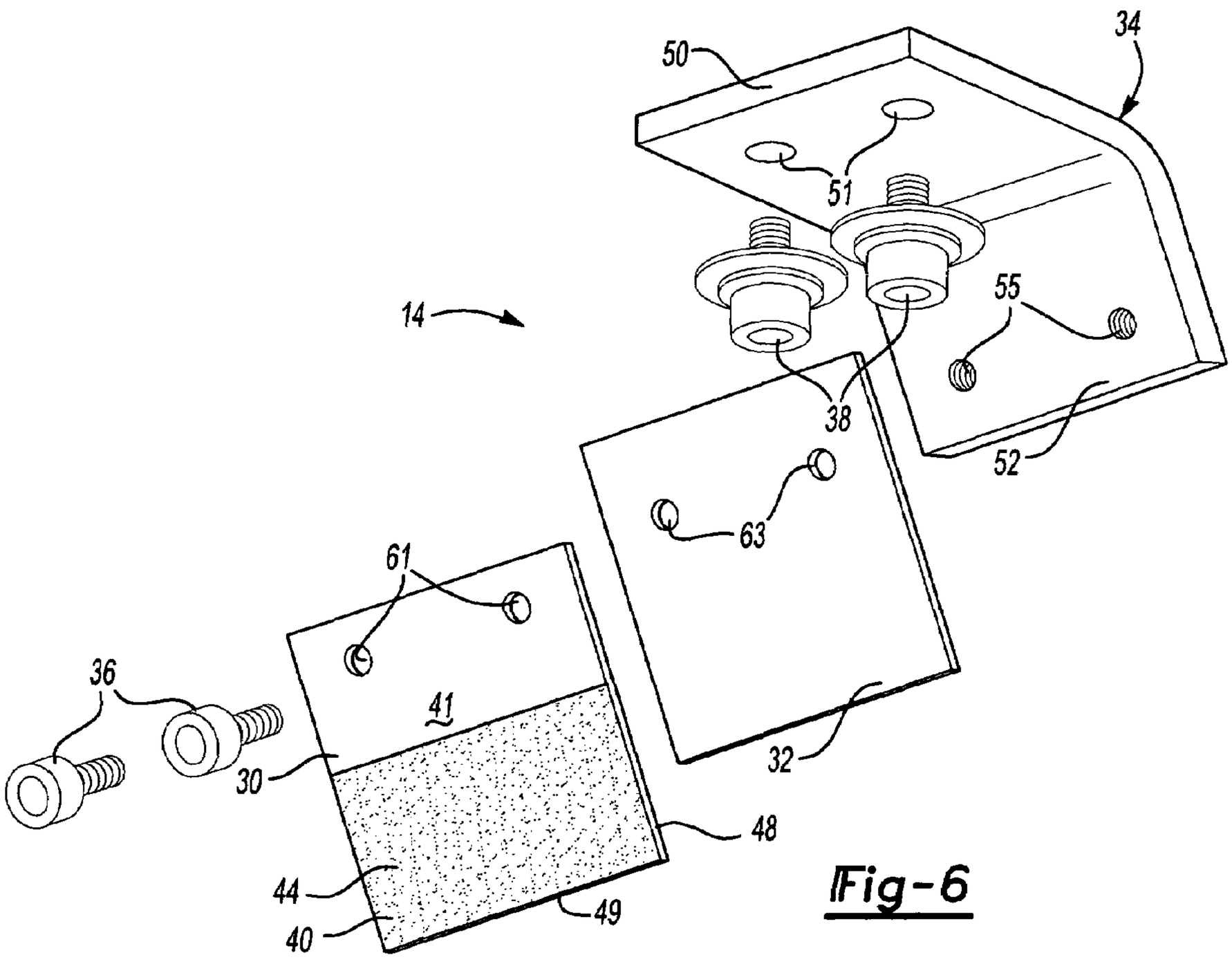
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Fig-6

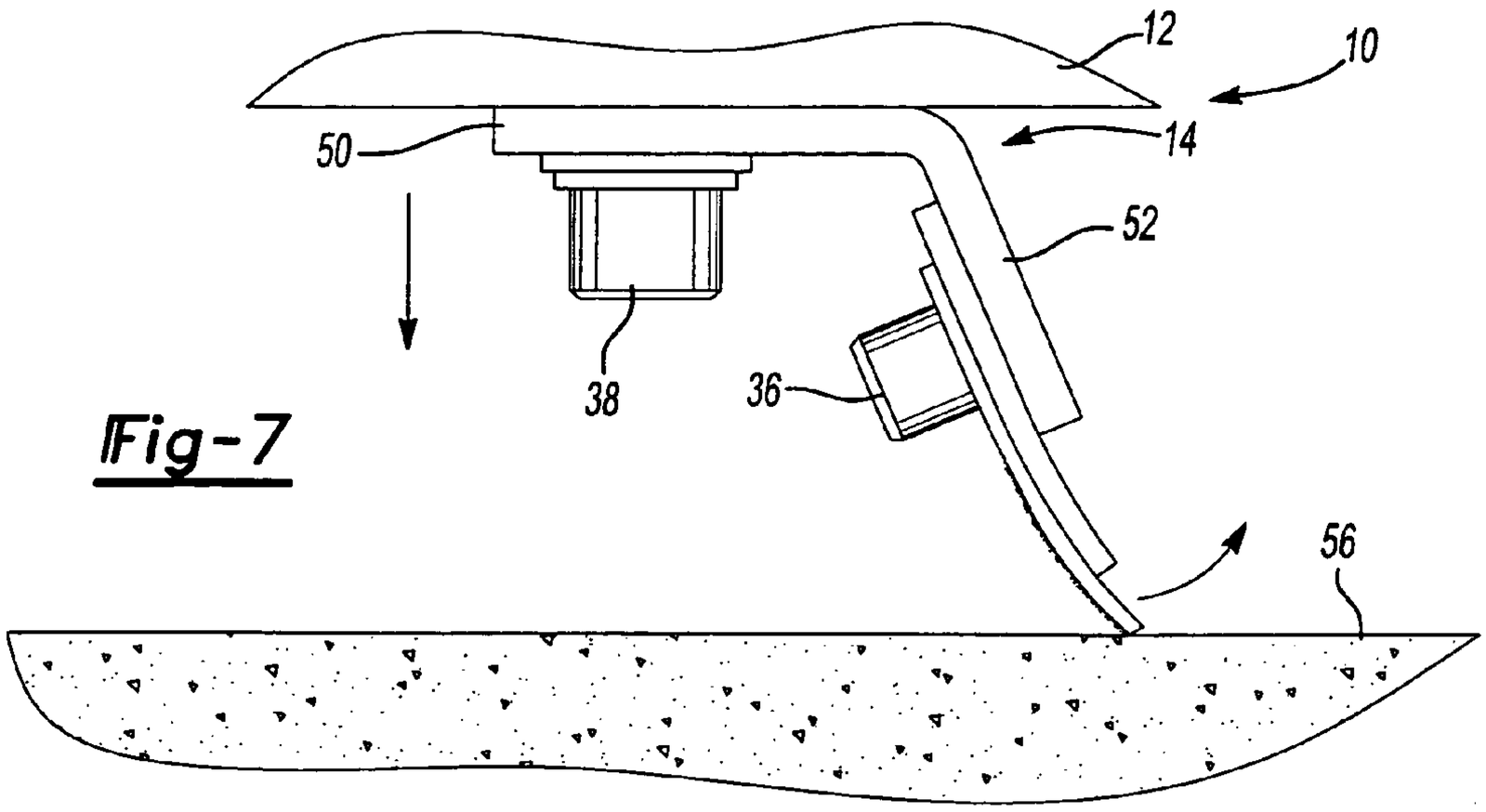

Fig-7

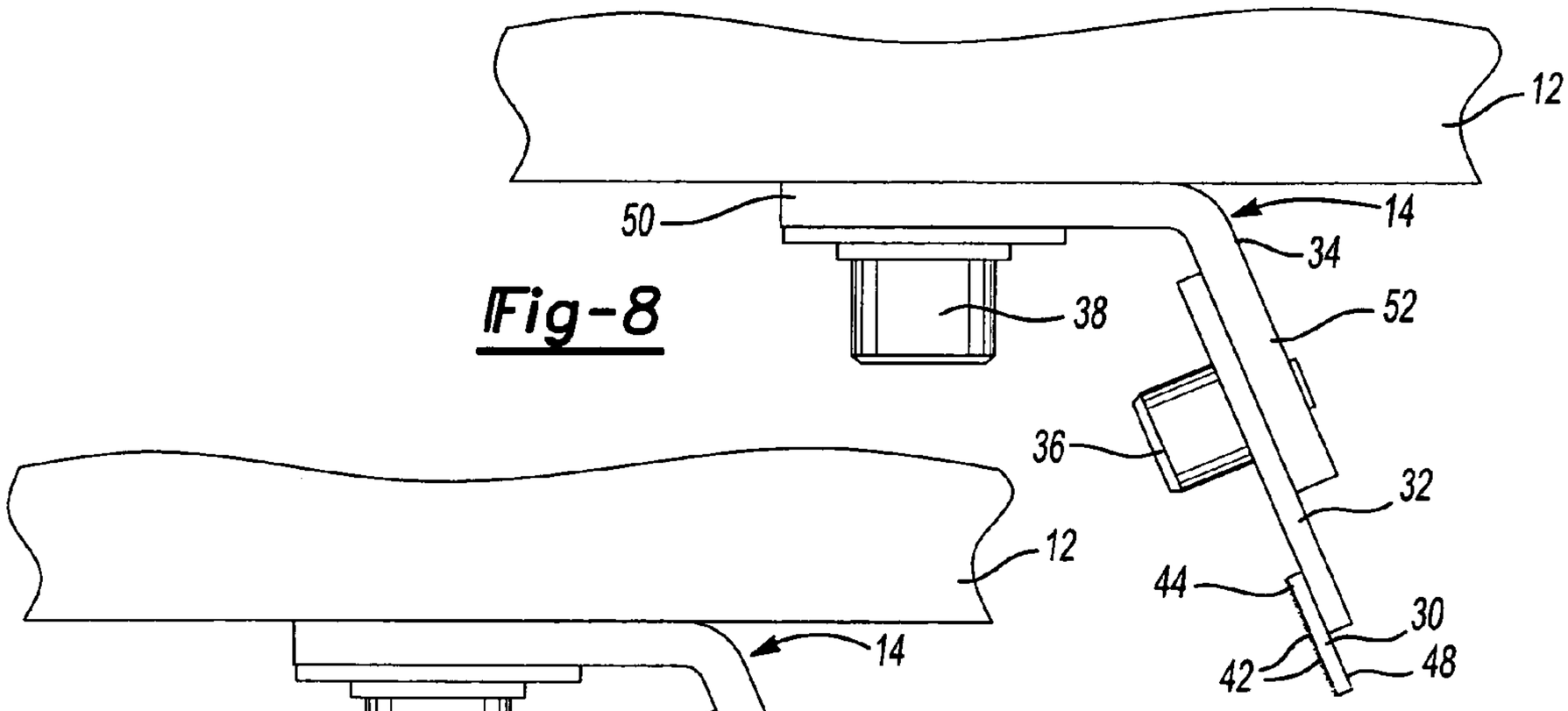

Fig-8

Fig-9

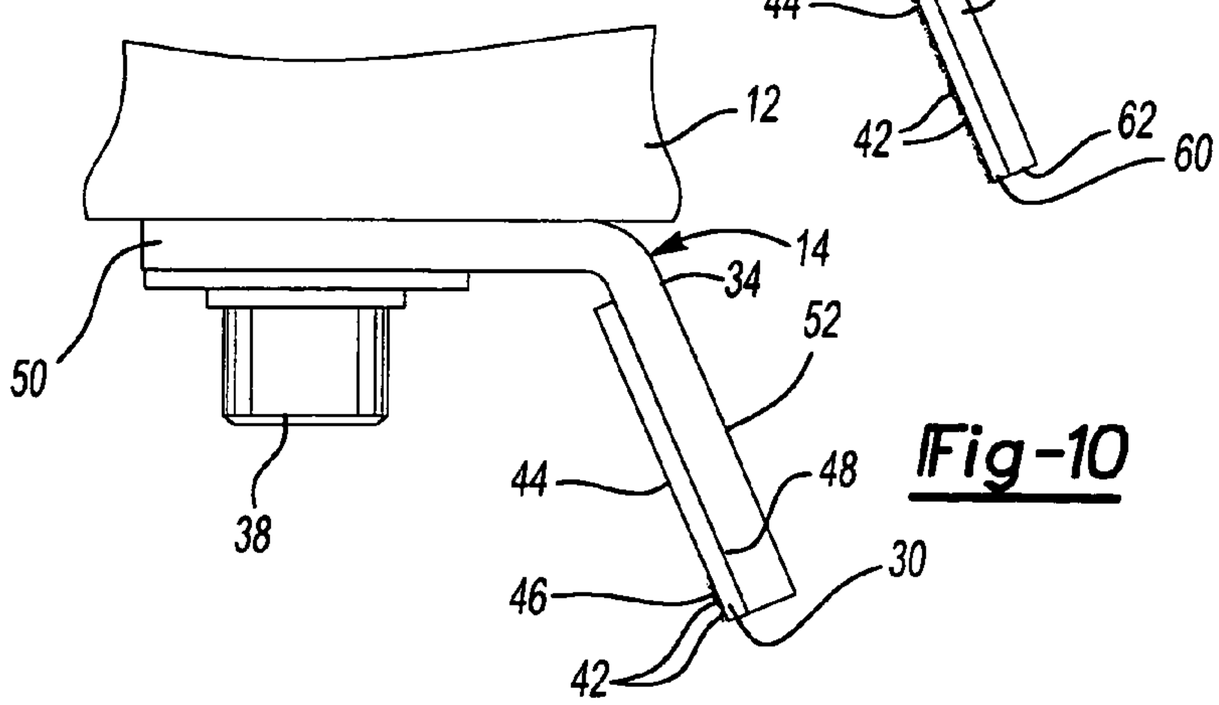

Fig-10

ABRASIVE PREPARATION DEVICE WITH AN IMPROVED ABRASION ELEMENT ASSEMBLY

TECHNICAL FIELD

The field of this invention relates to a reinforced abrasive abrading and grinding device for sanding hard floors and surfaces, for example cement, stone or imitation stone.

BACKGROUND OF THE DISCLOSURE

While concrete or cement is a very popular material for use in floors and construction materials because of its strength, durability and low costs, if the concrete or cement is left unfinished, the concrete floor will inherently produce dust by the constant scuffing it undergoes whether by foot traffic or wheeled traffic and be susceptible to staining due to porosity.

One is thus faced with a dilemma of cleaning a concrete floor with its no gloss utilitarian appearance and with the disadvantage of the inevitable dust that emanates from an unfinished concrete floor or spending considerable money for a protective and decorative covering surface. Vast improvements in coatings for concrete floors have taken place in the recent past and one may also desire to remove an older worn or failed coating and replace it with one of the newer type coatings. Part of the expense to obtain a decorative and protective covering is due to the preparation of the concrete floor to accept the new covering surface. The preparation often includes aggressive sanding to rough up the concrete surface and to remove any previously applied top coating, oil, or grease stains to assure proper adhesion of the new covering. Aggressive sanding of the concrete surface with conventional sand paper on sanding machines is a time consuming effort requiring frequent replacement of the sand paper as the sand particles become worn.

Attempts for more aggressive sanding and grinding pads have incorporated hardened particles such as diamonds or silicon carbide. While these pads performed well when new, it has been found that only a small percentage of the particles actually touch the surface at a give time. The cutting edges of these few engaging particles become rounded out through wear and the sanding performance substantially diminishes. In the trade, this is sometimes referred to as a ball bearing effect because the few now rounded diamond particles glide over the surface and no longer effectively cut into the surface.

Other problems are known that also prevent or limit the application of hardened particles. The present application of an abrasive bristle made from today's known higher temperature plastic materials when combined with the aforementioned hard abrasive materials generate much heat when used on a high speed power sander. The generated heat is sufficient to melt the plastic material and fuses the abrasive bristles together rendering the bristle pad useless.

The high heat and slow grinding rates pose particular problems for preparation of concrete surfaces that have mastic or older plastic and paints previously coated thereon. The heat melts the old coating materials as it is removed and the coating then adheres to and gums up the bristles which then quickly lose most of their sanding and grinding effectiveness.

Previous attempts to produce metal bristles also encountered problems. Attempts have been made to provide hard particles such as silicon carbide or diamond secured onto a bristle strip, blade or plate. The hard particles may be diamond particles brazed onto spring steel or other metal substrate. If the metal substrate is fully brazed with particles, the substrate becomes too brittle and breaks off during high speed

application. Even spring steel loses its resilient spring nature after it undergoes brazing. Attempts to limit the diamond particles only to the extreme ends or tips of the bristles to maintain the flexibility of the metal dramatically shorten the workable life of the bristle.

What is needed is an abrasive device for concrete sanding that has an improved performance profile by incorporating hardened particles only along a front face of a distal section of a substrate layer and which expose new particle edges as the substrate layer wears down. What is also needed is a flexible metal abrasive element with hardened particles secured thereon with the brazed section only on a front facing distal section of a substrate layer. What is also needed is a metal substrate layer with particles brazed thereon and further reinforced and supported by a resilient backing element to maintain sufficient flexibility and support of the metal substrate layer.

What is also needed is a durable abrasion element assembly for mounting to a cleaning or sanding machine that is suitable for preparing cement floors for coating. What is also needed is an expedient method to prepare a polished concrete floor to cut away plastic, mastic and the other heat sensitive materials by an aggressive cutting which forms enough concrete dust to coat the removed waste product before it can stick or adhere to the surfaces of the abrasion element assembly. What is also needed is an abrasion element assembly that has abrasive particles securely affixed to a substrate layer that is reinforced and supported by a resilient backing layer. What is also needed is an efficient sanding element that can be used with decreased horsepower most commonly available on consumer oriented sanding and cleaning machines.

SUMMARY OF THE DISCLOSURE

In accordance with one aspect of the invention, an abrasive surface preparation device for hard surfaces has a housing, for example a rotatable pad that rotates about its center, for moving over a hard work surface, for example cement, stone, tile or synthetic materials. The housing has a plurality of downwardly extending abrasive elements having a forward facing respective abrasive face with a width and length. Each abrasive element has a substrate layer and an abrasive material secured to the front surface of the substrate layer. Each substrate layer is reinforced by a backing element. The backing element is affixed to the housing such that the forward facing abrasive face of the generally faces the normal direction of motion of the housing. In another embodiment, the substrate layer is adhered to the backing element with an adhesive bond.

Preferably, the substrate layer and the backing element depend downwardly from the housing and are canted between 5° and 75° and most desirably between 25° to 60° from the perpendicular such that the distal lower ends of the substrate layer and backing element are positioned rearwardly of the proximate mounted section at the housing during normal motion of the housing. The abrasive material faces generally forward toward the motion of the housing.

It is also desirable that the substrate layer and the backing element are in abutting relationship with each other and both are affixed to a mounting bracket. The mounting bracket in turn is affixed to the housing.

Preferably, the abrasive elements are circumferentially spaced on the rotatable pad in proximity to its periphery. In one embodiment, the abrasive elements have their respective front abrasive faces substantially radially aligned with the rotational center of the rotatable pad.

The abrasive material is desirable diamond particles. The diamond particles may have varying sizes between 3.4 millimeters diameter and 0.5 microns, i.e., between 5 mesh and 120 mesh. The abrasive particles are desirably secured via brazing with a brazing material on a distal section of the front surface of the substrate layer. The proximate front section and rear surface of the substrate layer are substantially devoid of the brazing material and diamond particles. The substrate layer is preferably made from a low carbon steel and the backing element is preferably made from a spring steel.

According to another aspect of the invention, an abrasive element assembly has a substrate layer with abrasive particles brazed with brazing material to a distal front section thereof. A backing element is affixed against and provides flex support and reinforcement for the substrate layer. A supporting bracket is affixed to the backing plate. The supporting bracket is constructed for being mounted to a movable housing of a powered abrading device for example a sander or cleaning machine.

The abrasive element assembly preferably has the upper section of the mounting bracket constructed for mounting to the housing and an incline depending section for mounting the backing plate and the substrate layer at an angle from a perpendicular. It is desirable that abrasive material made from diamond particles is secured with a brazing material only at a front distal section of the substrate layer.

BRIEF DESCRIPTION OF THE DRAWINGS

Reference now is made to the accompanying drawings in which:

FIG. **1** is a bottom perspective view of an abrasive pad incorporating one embodiment of the invention;

FIG. **2** is a top perspective view of the pad shown in FIG. **1**;

FIG. **3** is an enlarged side elevational view illustrating one abrasion element assembly shown in FIG. **1**;

FIG. **4** is an enlarge front elevational view of the abrasion element assembly shown in FIG. **3**;

FIG. **5** is an enlarged rear elevational view of the abrasion element assembly shown in FIG. **3**;

FIG. **6** is a side exploded view of the abrasion element assembly shown in FIG. **3**;

FIG. **7** is a view similar to FIG. **3** illustrating the abrasion element assembly in a working and flexed position on a concrete surface;

FIG. **8** is a method of attaching the bristle shown in FIG. **7** to a side elevational view illustrating a second embodiment of an abrasion element assembly;

FIG. **9** is a side elevational view illustrating a third embodiment of an abrasion element assembly; and

FIG. **10** is a side elevational view illustrating a fourth embodiment of an abrasion element assembly.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

Referring now to FIG. **1**, a rotatable abrasive preparation device **10** includes a housing, for example in the form of a pad or disc **12** as illustrated that has a plurality of abrasive element assemblies **14** circumferentially mounted near the periphery **16** of disc **12**. The rotatable disc **12** as shown in FIG. **2** has a mounting aperture **20** in its upper face **18** and conventional snap lock **22** for operably connecting to a drive spindle of a conventionally powered abrading machine for example, a cleaning machine, buffing machine, or sanding machine. The disc **12** is constructed to normally rotate about its center axis **24** in a direction as indicated by arrow **26**.

The brazing material **46** may be Nicro Braze LM or other commercially available brazing material. The diamond particles **42** may also be plated onto the substrate layer **30**. The grit size of the diamond particles may be widely varied. It is foreseen that particle sizes of about 5 mesh to 500 mesh or even finer particles sizes can be used. It is preferred that the diamond particles **42** are a blend of different mesh size particles ranging from the 5 mesh size to the 120 mesh size with a great weight percentage of the diamond particles being varied between 16 mesh (1.2 mm) and 120 mesh (110 microns).

The backing layer **32** is in abutting relationship to the rear surface **48** of substrate layer **30**. The backing layer **32** can be made from any wear resistant material such as metal or a high temperature polymer but a resilient spring quality metal such as spring steel is preferred. The spring steel layer **32** is not brazed in order to retain its spring and resilient ductile quality. The spring steel backing layer **32** abuts a substantial portion of the rear surface **48** of substrate layer **30** as shown in FIGS. **3** and **5** and provides reinforcement support to the substrate layer **30**. In some applications, a distal end section **60** of substrate layer **30** may extend beyond the end **62** of backing layer **32** to provide operating edge **49** beyond end **62**. In other applications it may be preferred that distal sections **60** does not extend beyond end **62** so that edge **49** is flush with the distal end **62** of the backing layer **32**.

The substrate layer **30** and backing layer **32** may be affixed to bracket **34**. The bracket **34** has an upper section **50** that seats flush against the disc **12**. The bracket **34** upper section can be mounted via threaded fasteners **38** that pass through apertures **51** therein and engage threaded apertures **53** in the disc **12**. The bracket **34** also has a depending canted section **52**. The cant is set at an angle to the perpendicular for example between 5 degrees and 75 degrees, but preferably between 25° and 60° with its distal end **54** trailing with respect to the direction of motion of disc **12**. Threaded fasteners **36** extend through apertures **61** and **63** in both layers **30** and **32** and engage threaded apertures **55** in bracket **34** to securely clamp the two layers **30** and **32** together and secure them to the depending canted section **52** such that the layers **30** and **32** extend along the same canted angle of bracket section **52**.

The substrate layer **30** and backing layer **32** may be affixed to bracket **34**. The bracket **34** has an upper section **50** that seats flush against the disc **12**. The bracket **34** upper section can be mounted via threaded fasteners **38** that pass through apertures **51** therein and engage threaded apertures **53** in the disc **12**. The bracket **34** also has a depending canted section **52**. The cant is set at an angle to the perpendicular for example between 5 degrees and 75 degrees, but preferably between 25° and 60° with its distal end **54** trailing with respect to the direction of motion of disc **12**. Threaded fasteners **36** extend through apertures **61** and **63** in both layers **30** and **32** and engage threaded apertures **55** in bracket **34** to securely clamp the two layers **30** and **32** together and secure them to the depending canted section **52** such that the layers **30** and **32** extend along the same canted angle of bracket section **52**.

The substrate layer **30** has its front surface **44** facing generally forward relative to the normal operating motion of the pad **12**. As shown, the front surface **44**, may be aligned with the radial center of the pad and its radial extending width is substantially transverse to the normal rotating motion of the pad. However, it should also be understood that the radial extending width can be set at other angles relative to the radial direction as long as the front surface **44** faces generally forward to operably expose the diamond particles **42**.

The lengths i.e. heights of the layers **30** and **32** are generally substantially greater than the thickness of the layers **30**

and **32** to allow flexibility of the layers **30** and **32** during certain sanding applications. A typical flex during certain sanding operation is schematically shown in FIG. **7** where the flex further increases the angle at which the front surface **44** engages the working floor surface **56**. In other applications, the support backing element **32** and the bracket **34** may be dimensioned to reduce or substantially eliminate the flex depending on the application

The width of the layers **30** and **32** as shown in the figures may be greater than its length so that each abrasive element assembly **14** resembles a blade. The relatively large width provides for greater structural integrity and decreases the number of individual assemblies **14** needed to be mounted onto the disc. However, the width can be substantially changed so that the assemblies **14** can appear to resemble more of a strip, needle, or bristle rather than a blade.

FIG. **8** illustrates a modified embodiment where the substrate layer **30** is adhesively secured to the backing layer **32** and does not extend up to fasteners **36**. Fasteners **36** clamp only backing layer **32** to the bracket **34**. The substrate layer by being shortened may have its entire front surface **44** brazed with brazing material **46** to secure diamond particles thereon. The rear surface **48** remains devoid of particles **42** and brazing material **46**.

FIG. **9** illustrates a third embodiment where the substrate layer **30** and backing layer **32** both have a distal end **60** and **62** ending at the same point such that edge **49** does not initially extend beyond the backing layer **32**.

FIG. **10** illustrates a fourth embodiment where the substrate layer **30** is adheredly bonded directly to the distal leg **52** of the bracket **34**. In this embodiment the leg **52** is dimensional to act and function as the support backing layer **32** shown in other embodiments. The bracket **34** is made of spring steel and its thickness and length are both dimensioned to provide the desired amount of resilient flex and backing support to substrate layer **30**.

It has been found that the construction of the invention provides for superior and more efficient performance than previous diamond or hard particle brushes. The weight and horsepower needed to effectively abrade with this improved abrasive device are substantially reduced such that the device **10** can be used on a consumer oriented cleaning or sanding machine rather than heavier more powerful industrial power machine.

Furthermore, the diamond particles by being brazed onto the substrate layer with the appropriate brazing material are sacrificial. In other words, the diamonds will wear off the brazed area before they become overly worn and rounded to expose other diamond particles with fresh sharp edges. Thus the performance profile of the abrasion element remains high until the entire distal section with the diamond is worn away. The sacrificing of the diamonds prevents what can be termed a ball bearing effect. If the diamonds stay on too long, they become rounded and lose their cutting edge. If the worn diamond particles remain on the substrate layer, only these worn round points remain in contact with the cement working surface and the rounded points merely glide over the surface without any effective cutting. They start to act more like a ball bearing rather than cutting edges with a resulting dramatic decrease of performance. The sacrificial nature of the diamonds prevents this decrease and maintains the performance level at or near when the abrasive element assembly is newly manufactured.

Furthermore, the speed at which the abrasion occurs renders sufficient concrete dust as the assembly cuts into both the concrete surface and any top coating such that the top coating as it melts is instantly covered with the dust to provide a dryer outer surface which prevents the melted paint, mastic or plastic from undesirably sticking to the abrasion element assembly. Conventional wisdom states one must slow down the aggression by slowing the machine down to prevent higher heat and melting of the plastic, mastic or paint coatings. However, a more aggressive cut through the melted plastic, paint, or mastic along with the concrete to provide a dust coating prevents the melted coatings from adhering to the abrasive element assembly.

Fasteners **36** and **38** provide an expeditious way to removably secure the operating parts **30**, **32** and **34** to the disc **12**. When the parts **30**, **32** and **34** need replacing, the parts can be easily removed and replaced as needed. It is foreseen however that other fasteners other than that shown may be used. It is further foreseen that the abrasive element assembly **14** may be replaceable cartridge that may be secured as a whole to the disc **12** via a slot or bayonet fitting.

In this fashion an abrasion device with as few as two or three abrasion element assemblies circumferentially spaced at the bottom of the disc pad in proximity to its periphery can provide for an efficient abrading device for preparation of a cement floor before applying a new coat thereon.

Other variations and modifications are possible without departing from the scope and spirit of the present invention as defined by the appended claims.

The embodiments in which an exclusive property or privilege is claimed are defined as follows:

1. An abrasive hard surface preparation device comprising:
a housing for moving over a work surface;
said housing having a plurality of downwardly extending abrasive element assemblies;
said abrasive element assemblies each having a mounting bracket, a substantially planar backing element secured to said bracket, and a substantially planar substrate layer including a distal edge secured to said substantially planar backing element;
an abrasive material secured to said substrate layer at least at the distal edge of the substrate layer such that the abrasive material will wear off before becoming overly worn;
said mounting bracket depending downwardly from said housing such that the substrate layer and the distal edge are canted from the housing.

2. An abrasive hard surface preparation device as defined in claim **1** further comprising:
said substrate layer and said backing element in abutting relationship with each other and both being affixed to the mounting bracket; and
said mounting bracket being affixed to said housing.

3. An abrasive hard surface preparation device as defined in claim **2** further comprising:
said housing being a rotatable pad made for rotation about a central point;
said abrasive element assemblies being circumferentially spaced about the pad in proximity to its periphery; and
said abrasive element assemblies being substantially radially aligned with the rotational center of said rotatable pad.

4. An abrasive hard surface preparation device as defined in claim **3** further comprising:
said abrasive material being diamond particles of varying mesh size; and
said abrasive material being brazed with a brazing material on the distal edge of said substrate layer, a proximate front section of said substrate layer being devoid of said brazing material and diamond particles.

5. An abrasive hard surface preparation device as defined in claim 3 further comprising:

said substrate layer being made from a low carbon steel; and

said backing element being made from a spring steel.

6. An abrasive hard surface preparation device as defined in claim 1 wherein said substrate layer is adhered to said backing element with an adhesive bond.

7. An abrasive hard surface preparation device as defined in claim 1 further comprising:

said substrate layer being made from a low carbon steel; and

said backing element being made from a spring steel.

8. An abrasive hard surface preparation device as defined in claim 1 further comprising:

said backing element being a depending leg integrally formed as part of a mounting bracket;

said substrate layer being affixed to said depending leg of said mounting bracket; and

said mounting bracket being affixed to said housing.

9. An abrasive hard surface preparation device as defined in claim 8 further comprising:

said substrate layer being made from a low carbon steel; and

said backing element being made from a spring steel.

10. An abrasive hard surface preparation device as defined in claim 8 further comprising:

said substrate layer adhered to said backing element with an adhesive bond.

11. An abrasive hard surface preparation device as defined in claim 1 further comprising:

said substrate layer having a thickness substantially smaller than said width and length of said abrasive face, said abrasive material includes diamond particles that wear off to expose other abrasive particles as said substrate layer wears down before said diamond particles become worn to the point of being ineffective to a predetermined amount.

12. An abrasive device comprising:

a substantially planar housing;

a substantially planar substrate layer having a distal front section and a distal edge having abrasive particles thereon, said abrasive particles are diamonds that wear off of the substrate layer before becoming overly worn, the abrasive particles have a mesh size in the range of 5-120;

a backing element being affixed against and providing flex support and reinforcement for said substrate layer;

a supporting bracket affixed to the backing element;

said supporting bracket constructed for being mountable to the housing; and

said supporting bracket having an upper section for mounting to said housing and an inclined depending section for mounting said backing element and said substrate at an angle that is between 5 degrees and 75 degrees depending downward from said housing such that the substrate layer and distal edge are between 5 degrees and 75 degrees from the housing.

13. An abrasive device as defined in claim 12, further comprising:

said abrasive material comprising diamond particles brazed with a brazing material only at a front distal section of said substrate layer.

14. An abrasive device comprising:

a substantially planar housing;

a mounting bracket having a mounting leg for mounting to a housing and a depending leg;

a subatantially planar substrate layer having a distal edge, at least the distal edge having abrasive particles thereon, said abrasive particles are diamonds that wear off of the substrate layer before becoming overly worn, the abrasive particles have a mesh size in the range of 5-120; and

said substrate layer having its rear surface in abutting relation with said depending leg and affixed thereto, said distal front section and distal edge of said substrate layer has a width and a length, said front section is positioned at an angle canted from the housing.

15. An abrasive device as defined in claim 14 further comprising:

said abrasive material comprising diamond particles brazed with a brazing material only at the distal edge and at a front distal section of said substrate layer; and

said diamond particles being a blend of mesh sizes.

16. An abrasive hard surface preparation device comprising:

a housing for moving over a work surface;

said housing having a plurality of downwardly extending abrasive elements having a major forward facing abrasive face with a width and length;

said abrasive elements each having a substantially planar substrate layer having a distal edge and an abrasive material secured to a major front surface of said substrate layer and the distal edge, said abrasive material including diamonds that can wear off before becoming overly worn; said major front surface and distal edge of said substrate layer is positioned at an angle that is between 5 degrees and 75 degrees depending downward from said housing;

said abrasive elements having a substantially uniform thickness;

said substrate layer being connected to the housing such that the major forward facing abrasive face generally faces toward the normal direction of motion of said housing; and

said substrate layer having a thickness substantially smaller than said width and length of said abrasive face and constructed such that said abrasive elements are sacrificed to expose other abrasive material as said substrate layer wears down before said abrasive material become worn to the point of being ineffective to a predetermined amount.

17. An abrasive hard surface preparation device as defined in claim 16 further comprising:

said substantially planar substrate layer depending downwardly from said housing and being canted from the housing such that the distal edge of the substrate layer is positioned rearwardly from where it is connected to the housing during normal motion of said housing.

18. An abrasive hard surface preparation device as defined in claim 17 further comprising:

said substrate layer being made from a low carbon steel.

19. An abrasive hard surface preparation device as defined in claim 16 further comprising:

said substrate layer being made from a low carbon steel; and

said substantially planar substrate layer depending downwardly from said housing and being canted from the perpendicular such that the distal edge of the substrate layer is positioned rearwardly from where it is connected to the housing during normal motion of said housing.

20. An abrasive hard surface preparation device comprising:

a housing for moving over a work surface;

said housing having a plurality of downwardly extending abrasive elements having a major forward facing respective abrasive face with a width and length, each said downwardly extending abrasive elements extend at an angle that is between 5 degrees and 75 degrees depending downward from said housing;

said abrasive elements each having a substantially planar substrate layer having a distal edge and an abrasive material with diamonds secured to a major front surface and a distal edge of said substrate layer;

said abrasive elements having a substantially uniform thickness;

said substrate layer being connected to the housing such that the major forward facing abrasive face and distal edge are canted from the housing and generally faces toward the normal direction of motion of said housing;

said substrate layer having a thickness substantially smaller than said width and length of said abrasive face and constructed such that said abrasive elements are sacrificed to expose other abrasive particles as said substrate layer wears down before said abrasive material becomes worn to the point of being ineffective to a predetermined amount; and

said substrate layer being made from a low carbon steel.

21. An abrasive hard surface preparation device as defined in claim **20** further comprising:

said substrate layer having abrasive particles being brazed thereon with a brazing material forming a bonding layer of said abrasive particles to said substrate layer.

22. An abrasive hard surface preparation device comprising:

a housing for moving over a work surface, said housing being a rotatable pad made for rotation about a central point;

said housing having a plurality of downwardly extending abrasive elements having a forward facing respective abrasive face with a width and length;

said abrasive elements each having a substantially planar substrate layer with a front surface and a distal edge and an abrasive material secured to the front surface and distal edge of said substrate layer, said abrasive elements being circumferentially spaced about the pad in proximity to its periphery, said abrasive elements having their respective front abrasive faces substantially radially aligned with a rotational center of said rotatable pad;

each abrasive element is mounted to a backing element;

said backing element being affixed to the housing such that the forward facing abrasive face generally faces the normal direction of motion of said housing;

said substrate layer and said backing element in abutting relationship with each other and both being affixed to a mounting bracket, said mounting bracket being affixed to said housing, said substrate layer and said backing element depending downwardly from said housing with said substrate layer, including its distal edge, being canted from the housing such that distal edge of the substrate layer and backing element are positioned rearwardly during normal motion of said housing with the abrasive material facing generally forward toward the motion of said housing, with the abrasive material facing generally forward in the direction of motion of said housing,

said distal edge of said substrate layer extending beyond said backing element for providing additional flexure; and

said substrate layer being made from a low carbon steel and said backing element being made from a spring steel.

23. An abrasive hard surface preparation device as defined in claim **22** further comprising:

said substrate layer having a thickness substantially smaller than a width and length of said substrate layer, said abrasive material is constructed such that said abrasive elements are sacrificed to expose other abrasive particles as said substrate layer wears down before said abrasive diamond particles become worn to the point of being ineffective to a predetermined amount.

24. An abrasive hard surface preparation device comprising:

a housing for moving over a work surface;

said housing having a plurality of downwardly extending abrasive elements having a forward facing respective abrasive face with a width and length;

said abrasive elements each having a substantially planar substrate layer, having a distal edge and an abrasive material secured to the front surface and to the distal edge of said substrate layer;

each abrasive element is mounted to a backing element;

said backing element being affixed to the housing such that the forward facing abrasive face generally faces the normal direction of motion of said housing;

said substrate layer having a major section abutting adjacent said backing element, said substrate layer and distal edge and said backing element depending downwardly from said housing and being canted from the housing such that distal edge of the substrate layer and backing element are positioned rearwardly during normal motion of said housing with the abrasive material facing generally forward toward the motion of said housing; and

said distal edge of said substrate layer extending beyond said backing element for providing additional flexure.

25. An abrasive element assembly comprising:

a support bracket, the support bracket including an upper section and a canted section, the canted section positioned at an angle between 5 and 75 degrees from the upper section;

a backing element affixed to the canted section;

a substantially planar substrate having a distal edge affixed to the backing element; the substantially planar substrate having abrasive particles affixed to at least the distal edge.

26. An abrasive element as in claim **25** wherein the substantially planar substrate layer including a front face and a back face and the diamond particles are only affixed to the front face.

27. An abrasive element as in claim **25** wherein the backing element includes a distal edge of the substantially planar substrate layer that extends beyond said backing element.

28. An abrasive element as in claim **25** wherein the abrasive is diamonds.

29. An abrasive element as in claim **28** wherein the mesh size of the diamonds is between 5 and 120.

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